

Nbv. 23

Work Order ID 76325

76325

Page 1

November-09-11 8:33:24 AM

Item ID: D4018-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Short Basket Lid Assembly (350)
Start Date: 09/11/2011 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 23/11/2011 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/09 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4018	C								

100 Weld per dwg A/R S.S. rod Batch: M115778 0.00
Large Fab
Memo 0.00
1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
Memo 0.00
Quality Control:

11/11/15 (1x)

BE 11.11.16

1 / 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo *** mask sides of hinge prior to powdercoat*** Start Time: 9:30 Oven Temperature: 3200F Finish Time: 10:00	0.00 0.00							
140 *140* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 118988 Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00							

Sulu

IXD M / 11/11/17

M117338

1 BL 11-11-17

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: _____	0.00							
160	used on w/b 76327								
Packaging	Memo	0.00							
Packaging	D4032-041								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

11/11/11
 1

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Picklist Print

November-09-11 8:33:28 AM

Page 1

Work Order ID: 76325

76325

Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D4018-1		Manufactured	No			100	Each	5.0000	2	2			
D4018-1									**				
Rib													

Location Loc Qty Loc Code

WA 5

72545 5

✓ D4018-3		Manufactured	No			100	Each	10.0000	2	2			
D4018-3									**				
Rib													

Location Loc Qty Loc Code

WA 2

72546 2

WA005 8

68479 2

73032 6

✓ D4016-3		Manufactured	No			100	Each	31.0000	3	3			
D4016-3									**				
Hinge Half, Lid													

Location Loc Qty Loc Code

WA 30

73630 12

74909 18

WA005 1

71941 1

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Page 2

November-09-11 8:33:29 AM

Work Order ID: 76325

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Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5 Manufactured No

100 Each 31.0000 6 6

D4018-5

Rib

**

BY 11/11/14

Location

Loc Qty

Loc Code

WA

18

74917

18

WA005

13

74636

13

6x

D4035-041 Manufactured No

100 Each 0.0000 1 1

D4035-041

Lid Rib Assembly, Fwd (350 Basket)

**

B74818 → 1x BY 11/11/14

D4035-043 Manufactured No

100 Each 2.0000 1 1

D4035-043

Lid Rib Assembly, Aft (350 Basket)

**

B73628 → 2x BY 11/11/14

Location

Loc Qty

Loc Code

WA006

2

73628

2

D2581 Manufactured No

100 Each 23.0000 2 2

D2581

Mounting Bracket

**

BY 11/11/14

Location

Loc Qty

Loc Code

WA

23

69739

2

70766

2

73762

19

2x

D4020-7 Manufactured No

100 Each 0.0000 1 1

D4020-7

Mesh (350 Basket Short, Lid)

**

B76331 → 1x

BY 11/11/15

November-09-11 8:33:29 AM

Shop Packet Print

Page 2

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Picklist Print

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Work Order ID: 76325

76325

Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-3

Manufactured No

100

Each

4.0000

1

1

D4021-3

Data Plate

**

M 11/11/14

Location

Loc Qty

Loc Code

WA

4

73632

4

D2728-3

Manufactured No

140

Each

0.0000

1

1

D2728-3

Dart Logo label

**

115050.

1x

1 BK 11-11-17.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

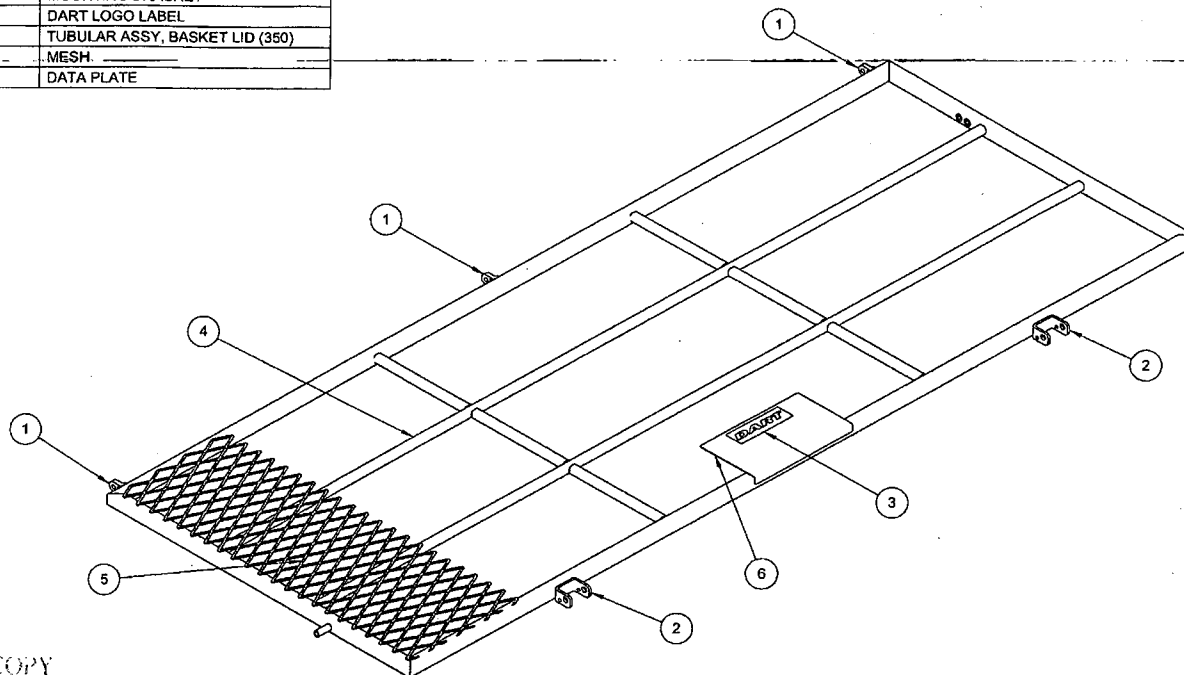
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76325 M.C.J
11/11/09

D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.05
ECIS 10-916

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4018 REV. C SHEET 1 OF 4 TITLE SHORT BASKET LID ASSY (350) SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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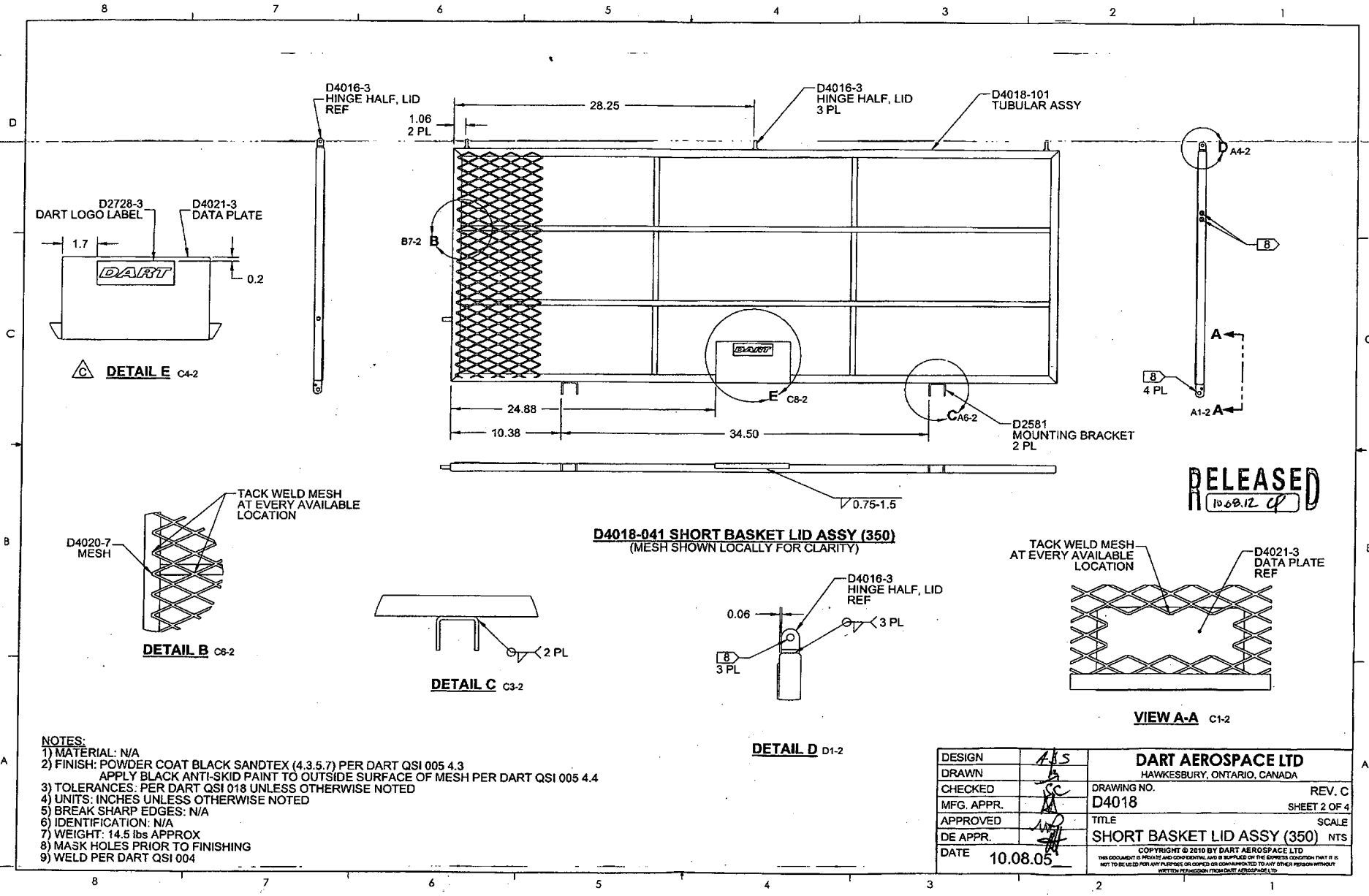
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76325



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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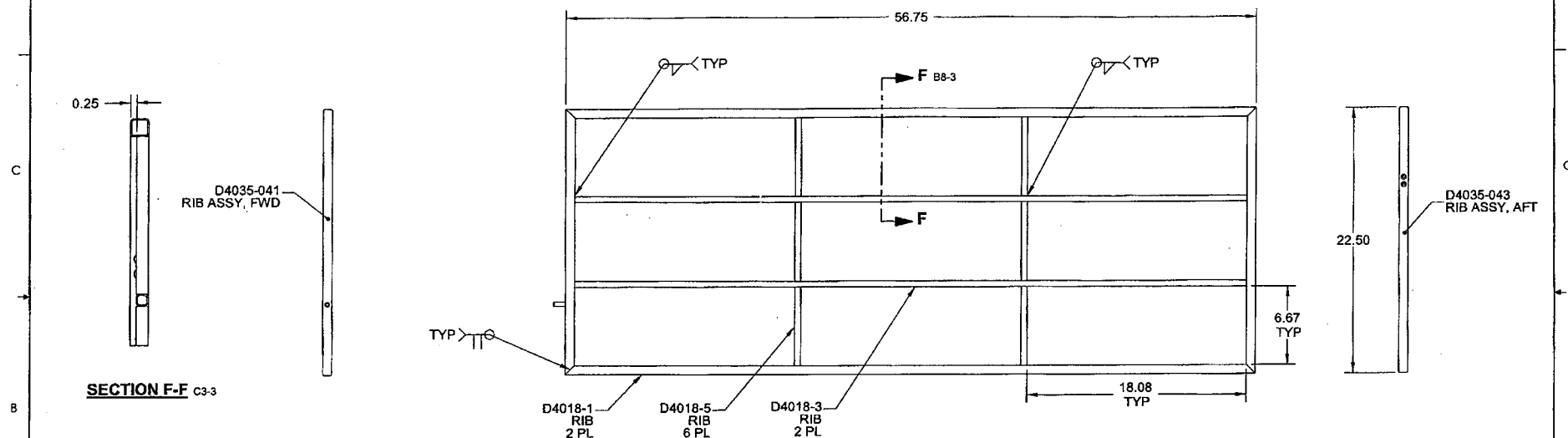
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	AS	DART AEROSPACE LTD	REV. C
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	D4018	SHEET 3 OF 4
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	SHORT BASKET LID ASSY (350)	NTS
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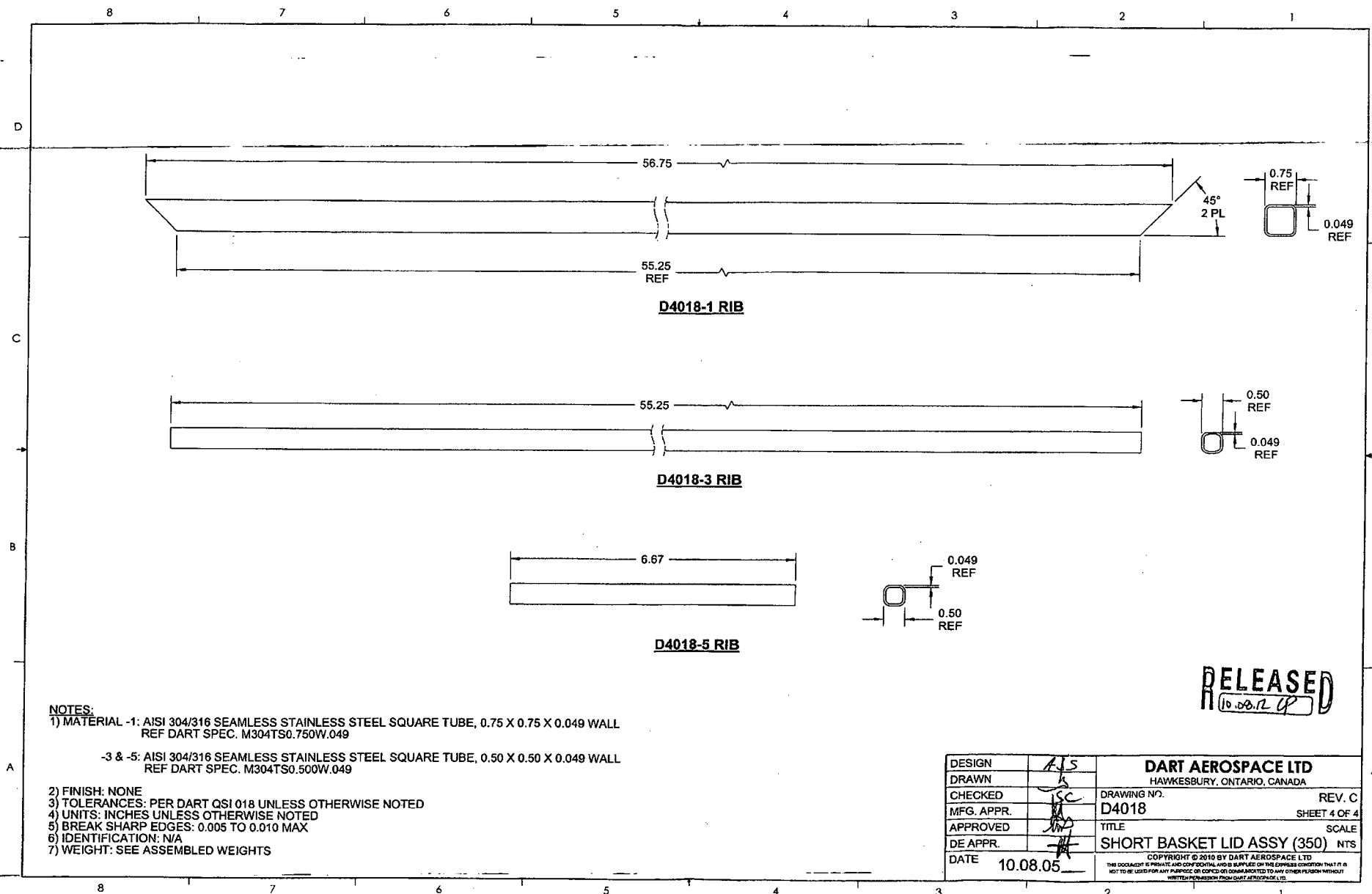
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